

ATTACHMENT V - GENERAL SPECIFICATIONS

GENERAL SECTION

This section includes items that may be used by all four uniformed programs of the Immigration and Naturalization Service. The items that a specific program can access from this section is controlled by that program's Section B of this contract.

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Note: All holsters will be provided to fit the pistol manufacturer and caliber size as stated in the individual specifications. Additionally, on a special order basis only, the holsters will be made available in the following styles and calibers:

- 1. Glock models 17 & 19 in 9mm**
- 2. Sig Sauer models P225 & P226 in 9mm**
- 3. Sig Sauer model P220 in .45**
- 4. Heckler & Koch models P7, P7M8 & P7M13 in 9mm**
- 5. Walther models P5 & P88 in 9mm**

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-01

Gun Belt

DESCRIPTION: Belt is a 2-1/4 inch wide plain black belt with a 1-1/4 inch billet style buckle attachment.

MATERIAL:

LEATHER: Full grain cowhide cut from shoulder section.
Free from scars and open cuts.

BUCKLE: Solid brass D style buckle with lacquer finish
to prevent discoloring.

SCREW POST: Chicago Screw Post

CONSTRUCTION:

1. Belt is constructed of two layers of leather glued and stitched together for a total thickness of 12-14 oz.
2. The billet style is stitched around the edge and sewn to the belt body.
3. The buckle is attached to one end along with three stitched belt keepers to hold the belt in position. Buckle is held in position with screw post.
4. All edges are burnished and finished for a smooth edge.
5. Belt outer layer and billet are dyed black and the belt is sealed with a lacquer emulsion to prevent the dye from rubbing off.
6. Belt size is two inches longer than normal waist size to fit over trouser belt and is marked with the waist size.

Strong model #983 or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-02

RIVER BELT

I. GENERAL DESIGN AND CONSTRUCTION

The lined River Belt is constructed of 6 to 7 oz. oak bark tanned cowhide with a semi-hard finish for the front portion and is lined with the same weight and quality of leather. The resulting weight being approximately 12 to 13 oz. in thickness. The billet shall be cut from the back of the hide and must be constructed from 9 to 10 holster leather. They shall be edged with a #3 edger and creased with a #5 creaser around those edges that are not stitched. The billet shall then be completely submerged in dye and the edges burnished to a smooth finish. After the billets are dry, they shall be dyed a second time and then finished with a high grade finish before being stitched to the body of the belt.

Belt and billet keepers shall be made from 6 to 7 oz. leather, dyed, and creased with a #5 creaser. They shall be cut to their proper length, that is to permit the billet and belt to slide through, yet without excess slack. All keepers must be stapled with two #14, 9/32 x 4 inch black staples.

The body of the belt, after the front and back have been laminated, shall be stitched around the outer edges approximately 1/8 inch from the leading edge of the belt. After stitching, the belt shall then be sanded smooth, and edged with a #3 hand edger. Dye shall then be applied to the edges and then burnished to a smooth finish using a high grade burnishing wax. The billet shall then be sewn to the body of the belt using the same type of thread. A #5 North & Judd solid brass buckle or equivalent shall then be attached to one end of the belt. The belt will be 2 1/4 inches in width.

II. DETAILS

1. EDGES - All edges are to be edged with #3 edger and dyed with a Flexolon water base epoxy acrylic edge sealer.
2. GLUING - Applied to both parts and pounded together
3. SEWING - Approximately six stitches per inch and sewn tightly
4. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
5. SANDING - All sewn edges are to be sanded smooth.
6. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIALS

A. LEATHER

1. Kind - Vegetable tanned cowhide
2. Weight - 6 to 7 oz., two straps
3. Grade - "A"
4. Other - Billets cut from grade "A", 9 to 10 oz. cowhide

B. HARDWARE

1. Buckle - #5, 1 1/4 inch North & Judd Style, solid brass or equivalent

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346 or equivalent
3. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - Will be dyed twice during the construction

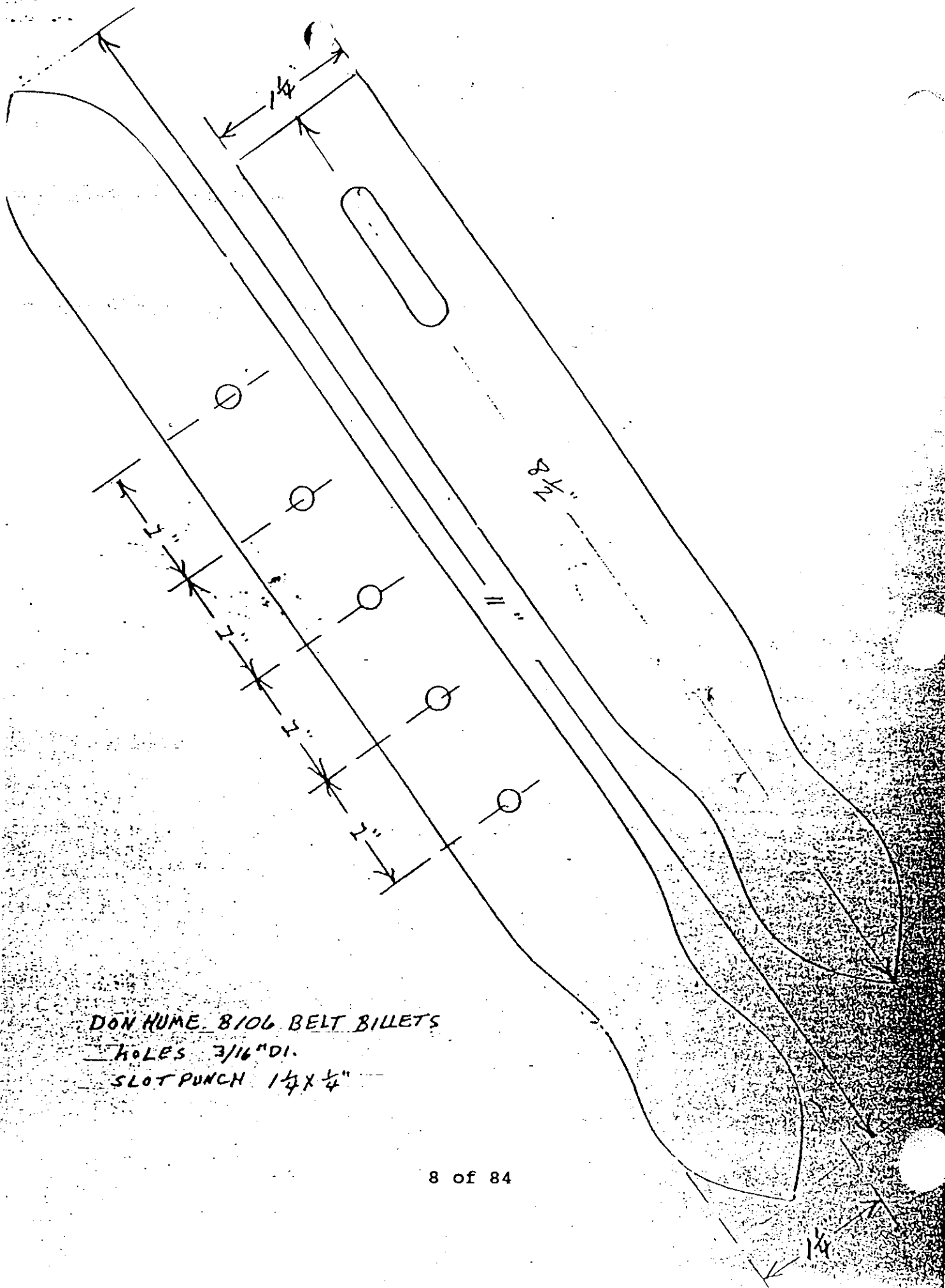
E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model B106 or equivalent.



DON HUME 8106 BELT BILLETS
HOLES 3/16" DI.
SLOT PUNCH 1 1/4 x 1/4"

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-03

SAM BROWNE BELT

I. GENERAL DESIGN AND CONSTRUCTION

The leather shall be cut to length and trimmed to accommodate the hardware. The first coat of dye shall be applied. A coat of glue is then applied to both the front and back of the belt. After lamination, the belt should be pounded together.

The hook end will be split back past the hole for the post. The hardware is then installed by gluing the end in place along with the buckle guard.

The buckle guard is designed to protect the user from the large belt buckle. The overall weight is 7 to 8 oz. in thickness. The edges in addition to the normal finishing procedures, must be stitched with a V346 mill dyed thread.

After the buckle guard is in place, the belt will be stitched around the outer edge, making sure the stitches are close to the hook, to prevent the hook from turning freely. The stitches will be 3/16 inches from the outer edge.

A 5/8 inch leather keeper shall be installed and a #4430 brass buckle shall be utilized.

Another set of stitches shall be sewn equal distance from the outer row of stitches.

Two brass dee rings, #4428, are placed in position for a shoulder strap. The dee rings shall be placed 5 5/8" and 14 1/2", respectively from the front edge of the belt on the right top side.

The belt shall be available in both right hand and left hand models.

II. DETAILS

1. EDGES - All edges to be edged with a #3 edger, dyed with Flexolon water base epoxy acrylic edge sealer or equivalent.
2. GLUING - Applied to both parts and pounded together.
3. SEWING - Approximately six stitches per inch, sewn tightly.
4. BURNISHING - All edges burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
5. SANDING - All sewn edges shall be sanded smooth.

III. MATERIALS

A. LEATHER

1. Kind - Cowhide made only from backs, oak bark tannage.
2. Weight - 6 to 7 oz., two straps
3. Grade - "A", full top grain
4. Other - 7 oz. buckle guard and 5/8" wide belt keeper

B. HARDWARE

1. Buckle - North & Judd #4430, or equivalent
2. Other - North & Judd #4614, Post #4125, and Dee rings #4428, or equivalent

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346
3. Other - Mill dyed to match color black.

D. DYE

1. Kind - Oil base Aniline dye
2. Other - Front side of belt to be dyed twice.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model B103 and B103-L (for women) or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-04

SHOULDER STRAP

I. GENERAL DESIGN AND CONSTRUCTION

The shoulder strap shall be made of two basic parts. First part known as the body, second part known as the billet. The body shall be cut to a 1 1/4 inch width and to a length measuring 6 inch less than the intended size of the completed strap. At one end, a North & Judd #4110-4077 post shall be installed to accommodate the leather fastening tab. The opposite end of the strap shall be tapered to a 7/8 inch, 7 1/2 inch from the end. It shall have six holes located 7/8 inch apart beginning 1 3/4 inch from the end.

The billet made from the same kind of material, shall be die cut to measure 1 1/4 inch at one end and tapered to fit a 7/8 inch buckle at the other. Another #4110-4077 style post and a leather fastening tab shall be attached to the widest end, and a North & Judd #4429 buckle shall be fastened to the opposite end with two nickel rivets. A keeper approximately 3/8 inch in width shall be placed on the billet. Two main parts shall then be buckled together forming a complete shoulder strap.

II. DETAILS

- A. EDGES - Edged with #3 hand edger, or equal, to give a rounded effect to edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. CREASING - All edges will be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

1. Kind - Selected bend portion, oak bark tanned top grain cowhide
2. Weight - 9 to 10 oz.
3. Grade - "A"

B. HARDWARE

1. Rivet - Two 3/8 inch tubular nickel rivets
2. Buckle - One North & Judd #4429 solid brass buckle, or equal. Two solid brass post and washers North & Judd #4410-4077, or equal, and 1 leather staple.

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346
3. Other - Mill dyed to match color black.

D. DYE

1. Kind - Oil base Aniline dye
2. Other - Leather Parts will be dyed twice.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement.

Don Hume Model S110 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-05

DOUBLE SNAP BELT KEEPER

I. GENERAL DESIGN AND CONSTRUCTION

The belt keeper is designed to keep the Sam Browne belt in a uniform position on the users waist. The width shall be 5/8 inches. The length shall be 7 1/2 inches. The two snaps will be located one inch apart beginning 1/2 inch from the two ends.

II. DETAILS

- A. EDGES - The length of the keeper shall be edged with a #3 hand edger, or equal, to give a rounded effect on edges.
- B. BURNISHING - All edges shall be finished with a Flexolon water base epoxy acrylic edge sealer.
- C. CREASING - The keeper shall be creased on both edges (on the top side) with a #5 creaser.

III. MATERIALS

A. LEATHER

- 1. Kind - Selected parts of vegetable tanned top grain cowhide.
- 2. Weight - 7 to 8 oz.
- 3. Grade - "A"

B. HARDWARE

- 1. Snap - Two durable dot snaps, solid brass.

C. DYE

- 1. Kind - Oil base Aniline dye
- 2. Other - Will be dyed twice.

D. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have a semi-gloss finish
3. Finish is plain (P) with solid brass snaps.

Don Hume Model S-502-1 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-06

DUTY HOLSTER #4

DESCRIPTION: Holster

The holster is a drop loop, covered trigger guard, thumb break design for 2-1/4 inch belt. Holster conforms to fit Speed Six 2-3/4 inch barrel.

MATERIALS:

LEATHER: Body-8-8 1/2 oz. top grain cowhide. Trigger guard and belt loop-7-7 1/2 oz. top grain cowhide

SNAP: Firm action solid brass snap with Black lacquer finish

THREAD: #346 Nylon Thread

SCREW POST: Chicago Screw Post - solid brass with Black lacquer finish.

CONSTRUCTION:

1. Outer layer leather is sewn to body to reinforce the trigger guard section.
2. Thumb break strap is doubled over for double thickness with a metal insert sandwiched between and sewn in place to stiffen thumb break section.
3. Holster is sewn and form fitted to the contour of specific gun. Trigger guard section is reinforced with screw post to prevent ripping at this critical point.
4. All edges are burnished and finished for a smooth edge.
5. Holster is dyed in a penetrating dye and sealed to prevent the dye from rubbing off.

Strong Holster Model H020-8 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-07

DESCRIPTION: STRAIGHT DROP HOLSTER

MATERIAL: Leather. Kind - Vegetable tanned top grain cowhide. Body Weight - 9/10 oz. Shank Weight - 8-8 1/2 oz. Grade - full grain. Other - Suede 2 oz.

HARDWARE: Durable dot snap, solid brass, black coated. One "T" nut plate assembly. Three special low head, long lock screws T-15. Metal plate - 14 gauge galvanized steel, reinforced with 16 gauge galvanized steel. Sight channel 20 gauge galvanized steel. One clock spring 3/4" x 1/2". One screw, oval head slot, solid brass, black coated. One BT-42 black screw post dime slot. One 8-32 x 1/2" black truss head screw long lock. One reinforced rubber tubing.

THREAD: V-346 Polyester - Mill dyed to match color of product.

DYE: Oil base Aniline dye. All parts will be dyed before assembly.

FINISH: Pigmented acrylic with top coat of Nitrocellulose. Must have semi-gloss finish.

GLUE: All purpose leather cement.

PROCESSES: To be edged with a #3 rampart hand edger or equal to give rounded effect on edges.

Glue applied to both parts and pounded.

Six stitches per inch and sewn tightly.

All edges burnished with a 3M deburring wheel using a hard burnishing wax.

All sewn edges to be sanded smooth.

GENERAL DESIGN AND CONSTRUCTION:

This holster is designed to fit the "K" frame - 3", Model 13.

The features of the H-738-SH are as follows: Jacket slot, Metal reinforced belt loop with belt locking device, straight drop, covered trigger guard, open bottom, suede lining, sight channel and gun tension screw adjustment.

The holster shall be constructed with three major parts; the reinforced belt loop, the holster body and the soft suede lining.

The belt loop will be made to fit snug on a 2-1/4" belt and the width of the loop will be 3-1/8" at the top part and taper down to 1" at the bottom.

A 4/5 oz. leather patch will be sewn in place at the belt opening to cover the metal plate.

The body parts will be cut from 5-6 oz/ full grain cowhide.

The body configuration will be such that after completion, it will form a thumb break over the hammer of the weapon and permit the trigger guard to be covered.

Before assembling the front and the liner, a clock spring will be placed between the parts at the thumb break tab, also, the "T" nut plate assembly will be placed between the layers to later secure the belt loop. There will also be a sight channel installed.

The belt loop assembly will be sewn to the holster body and further secured by three special low head socket screws placed through the belt loop assembly and attached to the "T" nuts.

The back welt will be glued and sewn in place and the durable snap will be attached at the thumb break.

After assembly, the holster will be wet molded, then an adjustable tension screw is installed.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-08

DUTY HOLSTER #5

DESCRIPTION:

The holster is a 2 slot high ride concealment holster with a covered trigger guard for up to 1 3/4" belt. Conforms to fit a Ruger Security Six 2 3/4" barrel.

MATERIAL:

LEATHER: Body-7-8 oz. top grain cowhide

SNAP: Firm action solid brass snap with lacquer finish.

THREAD: #138 Nylon thread

CONSTRUCTION:

1. Thumb break position of strap is double thick with a metal insert sandwiched in between and sewn in place to stiffen thumb break section.
2. Holster is sewn and form fitted to the contour of the specific gun. Critical areas are doubled stitched to prevent wear at the stress points.
3. All edges are burnished and finished for a smooth edge.
4. Holster is dyed in a penetrating dye and sealed to prevent the dye from rubbing off.

Strong Holster Model H290 First Chance or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-09

DUTY HOLSTER #1

I. GENERAL DESIGN AND CONSTRUCTION

The holster will basically be constructed of two major parts: the body which forms the pocket encompassing the weapon and the loop serving to cover the metal and forming the belt loop. The body of the holster shall be cut, allowing the holster to come just below the rear sight of the gun, nearly covering the cylinder and leaving the trigger and guard completely exposed.

A wedge shaped plug will be sewn onto the belt loop in a position so that when the holster is constructed, the plug will be at the top of the welt. A plate cover will be sewn onto the back inside portion of the loop to serve as a cover for the metal, extending into the loop. A welt piece will be sewn into the rear portion of the holster, giving the holster strength. A tear shaped muzzle plug will be sewn into the bottom of the holster to prevent wear on the muzzle of the weapon. A metal piece bent to contour the waist, the hip, and the cylinder of the gun, will be built into the back portion of the holster and shall extend into the belt loop.

A safety strap will be riveted to the back of the belt loop so that it can be pivoted freely. A durable dot snap is to be installed at the front of the holster, in a position to prevent the back of the snap from touching the gun. The other portion of the snap shall be located on the safety strap and positioned to allow the strap to fit snugly over the hammer of the weapon.

The muzzle plug and welt will be saddle stitched beginning at the top of the welt. There will be no loose ends to tie offs at any point except at the bottom of the welt. The stitching shall begin at the top of the welt, continue down and around the muzzle plug before tie off. A seven cord right twist linen thread treated with bees wax shall be used.

All parts will be edged and burnished to eliminate sharp edges. All leather pieces will be dyed with a quality fast dye before the construction of the holster. An all purpose leather cement is to be used to assemble the parts. All glued parts will be stitched in place with a lock stitch. Polyester V346 three strand thread approximately six stitches per inch will be used. All edges of the holster shall be sanded and burnished to a smooth finish.

After assembly of the holster, it will be wet molded to the weapon for which it is intended.

II. DETAILS

- A. EDGES - To be edged with a #3 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch, sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel using a hard burnishing wax.
- E. SANDING - All sewn edges will be sanded smooth.
- F. CREASING - All unsewn edges will be creased with a #5 hand creaser.

III. MATERIALS

A. LEATHER

- 1. Kind - Vegetable tanned cowhide
- 2. Weight - 9 to 10 oz.
- 3. Grade - "A", Top Grain

B. HARDWARE

- 1. Snap - Durable dot, solid brass.
- 2. Rivet - Stimpson - CE125 5/16 Nickel/Steel or equivalent
- 3. Metal Plate - 18 gage galvanized

C. THREAD

1. Kind - Polyester V346
2. Size - Three Strand
3. Other - Mill dyed to color black.

D. DYE

1. Kind - Oil base Aniline dye.
2. Other - All parts will be dyed before assembly.

F. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

G. GLUE

1. Kind - All purpose leather cement.

Holster must be available in both right and left hand models designed to fit the following 4 inch revolvers: S & W "K" and "L" frame, Ruger Security Six and Speed Six.

Don Hume Model H216-SG or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-10

DUTY HOLSTER #2

I. GENERAL DESIGN AND CONSTRUCTION

The features of the holster are: jacket slot, metal reinforced belt loop with belt locking device, straight drop, covered trigger guard, open bottom, suede lining, sight channel and gun tension screw adjustment.

The holster shall be constructed with three major parts: the reinforced belt loop, the holster body and the soft suede lining.

The belt loop will be made to fit snug on a 2 1/4" belt and the width of the loop will be 3 1/8" at the top part and taper down to 1" at the bottom.

A 4 to 5 oz. leather patch will be sewn in place at the belt opening to cover the metal plate.

The body parts will be cut from 5 to 6 oz. full grain cowhide.

The body configuration will be such that after completion, it will form a thumb break over the hammer of the weapon and permit the trigger guard to be covered.

Before assembling the front and the liner, a clock spring will be placed between the parts at the thumb break tab; also, the "T" nut plate assembly will be placed between the layers to later secure the belt loop. There will also be a sight channel installed.

The belt loop assembly will be sewn to the holster body and further secured by three special low head socket screws placed through the belt loop assembly and attached to the "T" nuts.

The back welt will be glued and sewn in place and the durable snap will be attached at the thumb break.

After assembly, the holster will be wet molded to fit the respective weapon. Then an adjustable tension screw is installed.

II. DETAILS

- A. EDGES - To be edged with a #3 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch, sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel using a hard burnishing wax.
- E. SANDING - All sewn edges will be sanded smooth.

III. MATERIALS

A. LEATHER

- 1. Kind - Vegetable tanned cowhide
- 2. Body Weight - 5 to 6 oz.
- 3. Shank Weight - 8 to 8 1/2 oz.
- 4. Grade - "A", Top Grain
- 5. Other - Suede 2 oz. plus 4 to 4 1/4 oz. leather

B. HARDWARE

Snap: Durable dot snap, solid brass, black coated
One "T" nut plate assembly
Three special low head, long lock screws T 15
Metal Plate: 14 gauge galvanized steel, reinforced with 16' gauge galvanized steel
Sight Channel: 20 gauge galvanized steel
One clock spring 3/4" by 4 1/4"
One screw, oval head slot, solid brass, black covered, 8-32 X 5/8" long lock
One "T" nut belt tension receptacle
One BT-42 Black screw post dime slot
One 8-32 X 1/2" black truss head screw long lock
One reinforced rubber tubing

C. THREAD

- 1. Kind - Polyester V346 or equivalent
- 2. Other - Mill dyed to color black.

D. DYE

1. Kind - Oil base Aniline dye.
2. Other - All parts will be dyed before assembly.

F. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

G. GLUE

1. Kind - All purpose leather cement.

Holster must be available in both right and left hand models designed to fit the following 4 inch revolvers: S & W "K" and "L" frame, Ruger Security Six and Speed Six.

Don Hume Model H738-SH or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

1992 - GN-11

DUTY HOLSTER #3

I. GENERAL DESIGN

The open muzzle holster mounts securely with an adjustable locking device on a standard 2 1/4" wide Sam Browne belt. The revolver is retained by spring action and a two part retaining strap system.

The features include an integral, over the hammer thumbsnap with metal reinforced release tab extension. A separate integral extension on the face of the holster extends up over the trigger guard and fastens securely to the back side of the holster. The holster is spring loaded and the spring mounts in a vertical slot at the fold of the holster extending from the top to approximately two-thirds down the middle of the holster.

The holster is 8 1/2" high by 4 1/2" wide by 2 3/4" thick and weighs 14 ounces.

II. CONSTRUCTION AND MATERIALS

The holster is constructed basically of two pieces: the face and the liner. Both the face and the liner shall be cut from nominal 8 oz. full grain, vegetable tanned cowhide. The leather shall be free of blemishes, brands, scars, fat wrinkles and other defects that would render the material unsuitable for the purpose intended.

Stitching:

All stitching shall be performed on a lock stitch type machine using 5 cord left twist waxed linen thread. Any stress areas shall be sewn with nylon thread. The number of stitches per inch shall be a minimum of six and a maximum of seven per inch. All perimeter stitching shall be 5/32" from the edge of the holster. Wherever applicable, perimeter stitching shall be performed in a continuous uninterrupted line, with a double stitch used at the start and stop of each stitching operation.

Prior to stitching, the face is embossed with a deep channel sewing guide. This sewing channel insures that the thread stitched does not extend above the surface of the leather; thus ensuring a minimum of thread abrasion during the useful life of the product.

Bonding:

Bonding is accomplished with a hot melt or waterbased polyurethane permanent cement. Wherever two exposed edges of leather are bonded, edges are trimmed to form a full round radius. The exposed rounded edges are then sanded smooth, burnished and finished with a suitable edge sealer. The finished product should appear to be constructed of one solid dimension; thus assuring material and construction integrity during the useful life of the holster.

Finish:

The leather shall be vat dyed with a minimum of 90% penetration and sealed. The sealer shall be of a material that does not crack or peel under normal use and provides a lustrous, satin finish appearance.

The plain holsters have a smooth face with a decorative crease line placed 1/8" from the edge.

All edges shall be trimmed in a full-round radius to remove sharp edges, then sealed with a permanent edge finish black in color.

Retainer Strap:

The retainer strap configuration is an integral extension of both the face and the liner of the holster so that there are no seams or separate parts to become snagged or accidentally disengaged. This provides a smooth outer surface of the holster with no visible retainer strap edges on the face of the holster. The retainer strap portion of the assembly extends from the front of the holster up over the top of the hammer and is fastened with a snap to the thumbsnap portion of the assembly. The thumbsnap is disengaged by the thumb of the drawing hand by exerting pressure in a sideways motion toward the wearer's body. The thumbsnap portion of the retainer strap device shall have a spring steel stiffener fastened between the layers of leather and secured by the cap and socket portion of the snap. The stiffener is 1/2" wide, 11/16" long and 20/1000" thick, with a full round radius at both ends.

Trigger Guard Strap:

Working in conjunction with the retainer strap device is a second strap which covers the trigger guard. This strap is an integral extension of the face and the liner of the holster which is folded up and over the trigger guard and then securely fastened to the back side of the holster with a brass self locking post.

Belt Loop and Shank:

The belt loop portion of the holster shall be fabricated from nominal 10 ounce, full grain, vegetable tanned cowhide with a nominal 5 ounce split leather pocket, and a heat-treated reinforced, spring steel metal shank. The metal plate measures 6 3/4" long and 1 1/2" wide. It shall include a recessed reinforcement channel as a metal strengthener, measuring 3" long and 1/4" wide running vertically through the shank. The belt loop shall be incorporated into the holster shank allowing a 4 1/2" deep space from attachment point on the belt loop to the top of the belt loop. The belt loop is attached to the holster by three (3) heavy-duty aluminum aircraft grade rivets affixed in a triangular pattern through 1/4" holes at the lower end of the belt loop metal stiffener and the holster shank.

Hardware:

All exposed hardware is of corrosion resistant material. The metal reinforced construction of the holster centers on two spring metal stiffeners. The belt loop metal stiffener and the holster metal shank are fabricated from #C1075 spring steel with a thickness of .062 of an inch. The belt loop metal stiffener shall be heat treated to a Rockwell hardness of 42 to 46. Both metal stiffener plates are secured by three flat head solid rivets of aluminum alloy 2117-T4 affixed in a triangular pattern at the lower end of both parts. Fastener components that may come into contact with the pistol shall be covered to prevent abrasion.

Holster must be available in both right and left hand models designed to fit the following 4 inch revolvers: S & W "K" and "L" frame, Ruger Security Six and Speed Six.

Bianchi Model 350 Hurricane or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-12

SPEEDLOADER 1

DESCRIPTION: Speedloaders will be available to fit Ruger Security/Speed Six and Smith & Wesson "K" & "L" frame revolvers.

Speedloader is designed to hold six rounds of ammunition. Ammo is placed in the speedloader and the knob is turned to lock rounds in position in the speedloader. When the rounds are inserted into the cylinder, the plastic collar is pushed to release them into the cylinder.

Safariland Comp II or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-13

SLIDE-ON HANDCUFF CASE

I. GENERAL DESIGN AND CONSTRUCTION

The handcuff case is constructed from three parts:

1. The back which also forms the cover flap.
2. The filler which is sewn to the back.
3. The mold which houses the handcuffs.

The back will be designed to fold over the pocket and act as a cover. Two slots will be cut in the back to accommodate a duty belt.

To assemble the case, the center piece will be glued and sewn to the back and the mold glued to this assembly and sewn in place.

II. DETAILS

- A. EDGES - To be edged with a #2 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.
- F. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIALS

A. LEATHER

1. Kind - Vegetable tanned cowhide with a semi-hard finish.
2. Weight - 9 to 10 oz.
3. Grade - "A", full top grain
4. Other - Filler weight 5 to 6 oz.

B. HARDWARE

1. Snap - One durable dot snap - Solid brass.

C. THREAD

1. Kind - V346 Nylon or equivalent
2. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye.
2. Other - All parts will be dyed twice during assembly.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have a semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement.

Don Hume Model C300 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-14

SNAP-ON HANDCUFF CASE

I. GENERAL DESIGN AND CONSTRUCTION

The handcuff case is constructed from four parts:

1. The small back piece.
2. The filler which is sewn to the back.
3. The mold which houses the handcuffs.
4. The flap.

After the flap has been processed and the snap installed, it is then sewn to the filler. The small back piece with the button portion of the snap installed, is then snapped in place on the flap and glued to the filler. A snap is installed in the mold and the mold glued in place on the flap assembly.

II. DETAILS

- A. EDGES - To be edged with a #2 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.
- F. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIALS

A. LEATHER

1. Kind - Vegetable tanned cowhide with a semi-hard finish. Special parts of the cowhide are to be selected to form the molded portion of the case in order to obtain a firm mold, assuring long wear and a nice appearance.
2. Weight - 8 to 9 oz.
3. Grade - "A", full top grain
4. Other - Filler weight 5 to 6 oz.

B. HARDWARE

1. Snap - One durable dot snap - Solid brass.

C. THREAD

1. Kind - V346 Polyester or equivalent
2. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye.
2. Other - All parts will be dyed twice during assembly.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have a semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement.

Don Hume Model C302 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-15

CARTRIDGE CASE

DESCRIPTION: The case is plain black leather designed to hold 6 rounds of 38/357. The case is divided into 3 separate sewn pockets to hold two rounds each. Case is designed to fit a 1 3/4 inch belt and not to open more than 45 degrees.

MATERIALS:

LEATHER: Full grain cowhide 6-7 oz. free from scars and open cuts.

SNAP: Medium action solid brass snap with lacquer finish to prevent discoloring.

RIVETS: Solid brass

THREAD: #346 Nylon thread

CONSTRUCTION:

1. Leather is cut and folded to form the three separate pouches and sewn between each pouch.
2. Leather support is riveted in place to prevent case from opening more than 45 degrees.
3. Case is molded to fit 6 rounds of ammo.
4. All edges are burnished and finished for a smooth edge.
5. Case is dyed in a penetrating dye and sealed with a lacquer emulsion to prevent the dye from rubbing off.

Strong Cartridge Case Model A526000 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-16

DESCRIPTION: CARTRIDGE CARRIER - 2

Cartridge Carrier is made of plain black leather. Designed to hold six rounds of 38/357. Loops are sewn on a separate strip on leather and then attached to the main body for easy access. Carrier snaps over a 2-1/4" belt.

MATERIAL:

LEATHER: 7-8 oz. full grain cowhide free from scars and open cuts.

Loop section - 3-4 oz. English Kip.

SNAP: Solid brass with a lacquer finish to prevent discoloring.

THREAD: #346 Nylon Thread

CONSTRUCTION:

1. Leather pieces are die-cut to proper size. Loop section is gauged to proper size and sewn to a separate leather piece. Loop assembly is sewn to main body.
2. Edges are burnished and finished to a smooth edge.
3. Leather is dyed in a penetrating dye and sealed with a lacquer emulsion to prevent the dye from rubbing off.
4. Brass snap is inserted as the final step.

Strong Snap on Cartridge Carrier Model #960-5 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-17

SNAP-ON SIX LOOP CARTRIDGE CARRIER (.38/.357)

I. GENERAL DESIGN AND CONSTRUCTION

The cartridge carrier is constructed of two parts:

1. The body is 3 1/2 inches wide and 6 3/4 inches long. The body will be folded in half and one snap shall be installed at the bottom opening.
2. The loops, 4 to 5 oz. in thickness, will be sewn to the body 1/2" from the fold and shall be sewn proportionately to accommodate six cartridges.

II. DETAILS

- A. EDGES - To be edged with a #3 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.
- F. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

1. Kind - Oakbark tanned with a semi-hard finish.
2. Weight - 7 to 8 oz.
3. Grade - "A"

B. HARDWARE

1. Snap - One durable dot snap, solid brass.

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346 or equivalent
3. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - All parts will be dyed twice during assembly.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose
2. Other - Must have a semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model D405 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-18

SNAP-ON 12 LOOP CARTRIDGE CARRIER (.38/.357)

I. GENERAL DESIGN AND CONSTRUCTION

The cartridge carrier is constructed of two parts:

1. The body is 6 1/2 inches wide and 6 3/4 inches long. The body will be folded in half and two snaps shall be installed at the bottom opening.
2. The loops, 4 to 5 oz. in thickness, will be sewn to the body 1/2" from the fold and shall be sewn proportionately to accommodate twelve cartridges.

II. DETAILS

- A. EDGES - To be edged with a #3 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.
- F. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

1. Kind - Oakbark tanned with a semi-hard finish.
2. Weight - 7 to 8 oz.
3. Grade - "A"

B. HARDWARE

1. Snap - Two durable dot snaps, solid brass.

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346 or equivalent
3. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - All parts will be dyed twice during assembly.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose
2. Other - Must have a semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model D405-1 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-19

SLIDE-ON 12 LOOP CARTRIDGE CARRIER (.38/.357)

I. GENERAL DESIGN AND CONSTRUCTION

The body of the case shall be constructed from leather measuring 6 1/2 inches x 6 inches. The 6 inch edges will be edged on both the top and bottom with a #3 hand edger. The part will then be vat dyed, the 6 inch edges will be creased with a #5 creaser and burnished to smooth finish.

The bullet loop material, 1/2 inches in width, will be stitched to a 1" wide spacer, 7/16" thick at the top and 5/16" thick at the bottom.

The filler will be stitched to the body approximately 3/8" from the fold. A 1/2" welt will be sewn at the bottom of the case and back-stitched not less than three stitches.

The loops will be sewn by a continuous stitch using the zig-zag method. Each end will be sewn with a double stitch to assure extra strength.

II. DETAILS

- A. EDGES - To be edged with a #3 hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.
- F. CREASING - All unsewn edges shall be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

1. Kind - Select cuts of vegetable tanned cowhide
2. Weight - 8 to 9 oz. for the body, 3 to 4 oz. for the loops
3. Grade - "A"
4. Other - Full top grain

B. THREAD

1. Kind - Polyester V346 or equivalent
2. Size - Three strand
3. Other - Mill dyed to match color black

C. DYE

1. Kind - Oil base Aniline dye

D. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

E. GLUE

1. Kind - All purpose leather cement.

Don Hume Model D411 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-20

SPEEDLOADER 2

DESCRIPTION: Speedloaders will be available to fit Ruger Security/Speed Six and Smith & Wesson "K" & "L" frame revolvers.

Speedloader is designed to hold six rounds of ammunition. Ammo is placed in the speedloader and the knob is turned to lock rounds in position in the speedloader. When the rounds are inserted into the cylinder, the solid metal knob is turned to release them into the cylinder.

HKS Models MK.3-A, 10-A and 586-A or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-21

DESCRIPTION: SPEEDLOADER CASE

Speedloader pouch to accommodate two Speedloaders. Speedloader pouches will be available to fit both HKS & Safariland speedloaders for Ruger Security/Speed Six and Smith & Wesson "K" & "L" frame revolvers.

Pouch is made of plain black leather with a single brass snap on each flap and is designed to fit a 2-1/4 inch belt.

LEATHER: 7/8 oz. full grain leather free from scars and open cuts.

SNAPS: Solid brass snaps with a lacquer finish.

FOAM: 1/2 inches foam to prevent rattle.

CUP: Black plastic cup to hold shape and proper height of speedloader.

CONSTRUCTION:

1. Leather belt loop, pouches and flaps are cut from leather and creased with a decorative outline crease.
2. All parts are stitched together to form pouch and belt loop.
3. Leather is dyed in a penetrating dye and is sealed with a lacquer emulsion to prevent the dye from rubbing off.
4. Snaps are added, then the cups and foam are inserted.

Strong Model A 520000 or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-22

TROUSER BELT (Plain Black) #2

I. GENERAL DESIGN AND CONSTRUCTION

The belt shall be first cut to the full width of 1 1/2 inches and the desired length.

Both ends will be trimmed with an English taper. At one end, a 7 1/2 inch length of Velcro (hook) will be glued and sewn on the front side. At the opposite end, a 7 1/2 inch length of Velcro (pile) will be glued and sewn to the back side of the belt. Both Velcro sides shall be an eighth inch in height.

II. DETAILS

- A. EDGES** - All edges shall be edged with #3 edger, dyed with Flexolon water base epoxy acrylic edge sealer.
- B. GLUING** - Applied to both parts and pounded together.
- C. SEWING** - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING** - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. CREASING** - A #5 creaser shall be made on the surface running edge.

III. MATERIAL

- A. LEATHER**
 - 1. Kind - Vegetable tanned cowhide
 - 2. Weight - 9 to 10 oz.
 - 3. Grade "A"
 - 4. Other - full top grain
 - 5. Velcro fastener material

B. THREAD

1. Kind - Polyester
2. Size - V346, Three cord

C. DYE

1. Kind - Oil base Aniline dye
2. Other - Belt will be dyed twice

D. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

E. GLUE

1. Kind - All purpose leather cement.

Don Hume Model B125 or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-23

TROUSER BELT (Plain Black) #1

I. GENERAL DESIGN AND CONSTRUCTION

The body of the belt shall be cut 6 inches longer than the required waist size and 1 1/2 inch in width. One end shall be cut at an English taper and the other cut square and skived 2 1/2 inch from the end. The skived portion shall be approximately 8 to 9 oz. in weight. A slot 1/8 inch x 3/4 inch will be located 1 3/8 inches from the square end. Holes for the billet snap will be punched 7/8 inch on center from the end and the other located 3/4 inch on the long side from the slot.

At the square end, a buckle billet will be sewn on the grain side and installed through the slot to the flesh side with the buckle snapped in place. The billet shall be cut from 8 to 9 oz. leather. On the tapered end of the billet it will be sewn 3 inches from the end to the body. On the buckle billets three keepers 3/8 inch in width will be installed; one 1 1/2 inch keeper on the body and two 3/4 inch keepers on the buckle billet.

On the opposite end of the body a 10 1/4 inch billet, with 5 round holes spaced 1 inch apart, will be sewn in place.

II. DETAILS

- A. **EDGES** - All edges are to be edged with a #3 edger and dyed with a Flexolon water base epoxy acrylic edge sealer.
- B. **GLUING** - Applied to both parts and pounded together.
- C. **SEWING** - Approximately six stitches per inch and sewn tightly.
- D. **BURNISHING** - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. **SANDING** - All sewn edges are to be sanded smooth.
- F. **CREASING** - All unsewn edges shall be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

1. Kind - Top grain skirting leather
2. Weight - 12 oz.
3. Grade - "A"
4. Other - shall be cut from the bend part of the hide

B. HARDWARE

1. Snap - Two Rau Black snaps Part No. 8020, 8029, 8031, 8042, or equivalent
2. Buckle - Waterbury 2344 3/4 inch or equivalent

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346 or equivalent
3. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - Will be dyed twice during construction

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose
2. Other - Must have a semi-gloss finish

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model B112 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-24

TROUSER BELT (Plain Black) #3

DESCRIPTION: Belt to be a 1-1/2 inch wide plain black belt with a D shape brass belt buckle.

MATERIALS:

LEATHER: Full grain cowhide cut from the shoulder section. Free from scars and open cuts.

SNAP: Hard socket brass snap with black non-glare finish.

BUCKLE: Brass finish D shape buckle with lacquer finish to prevent discoloring.

CONSTRUCTION:

1. Belt is made of a 7-9 oz. leather stitched on outer edge for decoration.
2. Belt is attached to one end and is removable. A 3/8 inch wide belt keeper is fastened between the two black snaps to hold end of belt in place.
3. All edges are burnished and finished for a smooth edge.
4. Belt outer layer of leather is dyed black and the belt is sealed with a lacquer emulsion to prevent the dye from rubbing off.
5. Belt size is marked with actual waist size.

Strong model #988 Trouser Belt or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-25

HATBAND

I. GENERAL DESIGN AND CONSTRUCTION

The hat band shall be constructed from 6 to 7 oz. cowhide cut 1 inch in width and to lengths to accommodate various sizes.

The ends shall be cut with a 3/4 inch radius on each end. The strap is to be pad dyed on the grain side and edge coated on the edges. The flesh or back shall be left natural but coated with a clear lacquer.

At one end a North & Judd #12 buckle will be attached by means of a billet, measuring 1/2 inch wide x 2 inches long. This billet is stitched at the buckle and again at the end. A 1/4 inch keeper will be installed on the billet.

At the other end of the hat band a billet measuring 1/2 inch x 5 1/2 inches will be sewn in place. Eight holes will be punched in the billet 3/8 inches apart with the first hole starting 1 1/2 inches from tip.

II. DETAILS

A. EDGES - All edges shall be edged with #3 edger, dyed with Flexolon water base epoxy acrylic edge sealer.

B. GLUING - Applied to both parts and pounded together.

C. SEWING - Approximately six stitches per inch and sewn tightly.

D. BURNISHING - All edges shall burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.

E. SANDING - All sewn edges shall be sanded smooth.

III. MATERIAL

A. LEATHER

1. Kind - Top grain cowhide
2. Weight - 6 to 7 oz.
3. Grade - "A"

B. HARDWARE

1. Buckle - #12 North & Judd solid brass or equivalent

C. THREAD

1. Kind - Polyester
2. Size - Three cord, V346
3. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - Front side of belt to be dyed twice

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose
2. Other - Must have semi-gloss finish

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model B107 or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-26

BATON HOLDER

MATERIAL: Polycarbonate

CONSTRUCTION: Molded two piece construction, 360 degree swivel.
Weight is approximately one ounce.

DESCRIPTION: Multi-position, 360 degree swivel baton holder. Molded Polycarbonate to fit the PR-24 XTS expandable side-handle baton. The holder is designed to fit both the Border Patrol River Belt and the Sam Browne Belt. The belt retaining device is 2 3/4" high by 1 1/2" wide by 2" long. The baton retaining device is 1 1/2" wide by 2 3/4" high.

COLOR: Solid black

MONADNOCK PC-H USBP or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-30

SHOE #1

DESCRIPTION: Black leather oxford/neoprene. Goodyear Welt Construction.

UPPER MATERIAL: Black smooth corrected grain leather.

QUARTER LINING: Nicotine Cambrelle 2 ply fused nylon with 3/32" foam back including tongue.

VAMP LINING: Nicotine Cambrelle 2 ply fused nylon.

INSOLE: 3 1/2 Iron Texon

INSOLE INSERT: Tentex covered polyurethane foam orthotically designed removable cushions with built in arch support and metatarsal pads.

BOTTOM FILLER: 1/8" closed cell rebound foam rubber

SHANK: Fiberglass

WALKING SURFACE: Outsole & Heel: 21 I Polyester polyurethane outsole with attached 9/16" polyester polyurethane heel.

MIDSOLE: 6 Iron black SBR rubber

COUNTER: 4000 weight heat activated non-woven synthetic fabric

BOX TOE: 30 weight Knilon ABS Core

WELT: 14/32 X 1/8 Black vinyl storm welt around heel

SOLE-STITCH: 7 cord black braided cotton

LACES: 30" black round nylon

BATES LITES #SR56 (FEMALE = SR748) OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-31

SHOE #2

STYLE: Black leather walker, plain toe, 4 eyelet

UPPER MATERIAL: Black smooth leather - bright finish HM weight

LINING MATERIAL: Black Cambrelle

FOUNDATION INSOLE: 4 1/2 I Texon

FOOT SUPPORT INSOLE: Removable, washable, support with arch support

SOLE AND HEEL: Slip resistant, light weight, meramec black

SHANK: Fiberglass

THREAD: Black

INSULATION: N/A

COUNTER: Stanbee

BOX TOE: Plastic

LACE: 27" black

TOPLINE PUFF COLLAR: Latex 3/8 foamcoat

EYELETS & HARDWARE: 1 extra long rollet black - 4 eyelet

CONSTRUCTION: Cement

Rocky model 2025 (Female = RB 115) or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-32

WESTERN BOOT #1

DESCRIPTION: 14" black leather western boot. Goodyear welt construction.

UPPER MATERIAL: Black smooth leather.

QUARTER LINING: Leather.

VAMP LINING: Drill.

INSOLE: 4-1/2 Iron Texon

OUTSOLE: 12 Iron 90 Abrasion, Hypalon Oil Resistant Sole.

HEEL: Rubber Western Walking

SHANK: Western

BOTTOM FILLER: Cork

COUNTER: Thermoplastic

BOX TOE: Polystyrene

WELT: Black Vinyl Flat Welt

SOLE-STITCH: Black Polyester

BATES #15, (FEMALE = #65) OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-33

WESTERN BOOT #2

DESCRIPTION: 14" black leather western boot. Goodyear welt construction.

UPPER MATERIAL: Black smooth leather.

QUARTER LINING: Leather.

VAMP LINING: Drill.

INSOLE: 4-1/2 Iron Texon

OUTSOLE: 12 Iron 90 Abrasion, Hypalon Oil Resistant Sole.

HEEL: Rubber Western Walking

SHANK: Western

BOTTOM FILLER: Cork

COUNTER: Thermoplastic

BOX TOE: Polystyrene

WELT: Black Vinyl Flat Welt

SOLE-STITCH: Black Polyester

JUSTIN 3040, (FEMALE = #3041) OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-34

UTILITY BOOT #3

STYLE: 8" Black light weight, Gore-Tex, non-insulated boot

UPPER MATERIAL: HH weight waterproof Black leather and 1000 DNR Cordura Nylon, black 2 X 2 Ballis Cordura

LINING MATERIAL: Nicotine Cambrelle with Gore-Tex fabric laminated between Cambrelle and E-knit. Gore-Tex bootie construction

FOUNDATION INSOLE: 6 Iron 244 Bontex cement

FOOT SUPPORT INSOLE: Removable, washable, ortho innersole support with arch, net and heel cup support

SOLE AND HEEL: Slip and oil resistant, dual density polyurethane mini lug sole unit

SHANK: Fiberglass

THREAD: Black

INSULATION: N/A

COUNTER: Waterproof Fiber 9091

BOX TOE: Plastic

LACE: 48" black round nylon

TOPLINE PUFF COLLAR: Theile soft black gusset

EYELETS & HARDWARE: Two AA eyelets and five D-ring gun metal color

CONSTRUCTION: Goodyear welt

Rocky model 8036 (Female = 410) or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-35

UTILITY BOOT #1

STYLE: 8" Black full grain leather boot

UPPER MATERIAL: Black full grain leather - medium bright finish, HM to H Weight, Chrome tanned

LINING MATERIAL: Cambrelle - Thinsulate

FOUNDATION INSOLE: 4 1/2 Iron Texon, non-shrinking

FOOT SUPPORT INSOLE: Removable, washable, support with arch support

SOLE AND HEEL: Slip resistant, long wearing, oil and gas resistant, dual density polyurethane

SHANK: Fiberglass

THREAD: Black polyester nylon, double stitched and tacked at stress points

INSULATION: Thinsulate

COUNTER: Fiber

BOX TOE: Bixby box toe

LACE: 57" Taslan black

TOPLINE PUFF COLLAR: Black Koram

EYELETS & HARDWARE: 5 eyelet tie, 3 D-ring, gun metal color

WELTING: Hemingway - black

MIDSOLE: 6 Iron

CONSTRUCTION: Goodyear welt

Rocky model 5066 (Female = 4070) or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-36

UTILITY BOOT #2

STYLE: 9" Black full grain leather waterproof boot with full Gore-Tex bootie liner.

UPPER MATERIAL: Black full grain waterproof 5 to 5 1/2 oz., cattle hide leather, semi-bright finish, drum dyed, chrome tanned.

LINING MATERIAL: Full cambrelle with 1/16 Limo foam, 3400 Thinsulate insulation, Gore-Tex fabric and E Knit backing.

FOUNDATION INSOLE: 6 Iron Texon #437 grade insole, non-shrink bacteria resistant.

FOOT SUPPORT INSOLE: Removable, washable, support ortho innersole with heel cup, arch and metatarsal supports, bacteria resistant, molds to individual foot.

SOLE AND HEEL: Style 25 dual density polyurethane E Heel and Sole. Non-marking, slip resistant to U. S. Gov. Spec. (SR.)

SHANK: Non-breaking fiberglass

THREAD: Black #139 Polyester/Nylon Belding Hemingway lock stitch

INSULATION: Thinsulate B-400

COUNTER: Molded, non-breakable, waterproof, firm fiberboard material.

BOX TOE: Molded poly. #16

LACE: 63" Taslan black Nylon

TOPLINE PUFF COLLAR: Leather top band inside puff collar

EYELETS & HARDWARE: Rust resistant, Black Japan brass speed laces and eyelets

WELTING: Goodyear welt, flat bar, flex

MIDSOLE: 6 Iron

BOTTOM FILLER: Besto Cork, flexible cushion pad

CONSTRUCTION: Goodyear welt construction with patented Gore-Tex bootie liner

Rocky model 7017 or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-37

CREW SOCK

DESCRIPTION: Socks shall be available in all sizes and so designed to provide extra toe, bottom, and heel support areas. The sock shall be crew style and at least 8" high from the heel to the top of the sock. Construction shall be approximately 85% orlon acrylic and 15% stretch nylon. Color shall be black.

THORLO STYLE WGX OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-38

BOOT SOCK

DESCRIPTION: Socks shall be available in all sizes and so designed to provide extra toe, bottom and heel support areas. The sock shall be BOOT style and at least 14" high from the heel to the top of the sock.

Construction shall be approximately 75% orlon acrylic and 25% stretch nylon. The stretch nylon upper top must be sufficient to keep the sock up over the calf area.

Color to be available in both black and white.

THORLO STYLE WDB OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-40

DRESS GLOVE

MATERIAL: The outer material shall be butter-soft grade native deerskin. Inner liners shall be constructed of 20% nylon and 50% wool blend.

CONSTRUCTION: The construction method shall be gauge-self with a gusseted wrist section.

DESCRIPTION: There shall be a workable closure at the wrist consisting of an adjustable strap with a snap and slide with roller loops. The liner shall be removable.

COLOR: The deerskin shall be dyed black. The liner color shall be black.

GATES STYLE 1886 AND 1886W (WOMEN'S) OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-41

WORK GLOVE

MATERIAL: Buck-tanned cowhide with 100 gram thinsulate and knit backing.

CONSTRUCTION: The construction method shall be half-self pique with elastic wrist.

DESCRIPTION: Modified sport glove with three rows of gripping on the palm. Adjustable velcro closure strap over the elastic wrist at vent.

COLOR: The cowhide shall be dyed black.

GATES STYLE 2335 AND 2335W (Women's) or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-42

CEREMONIAL DRESS GLOVE

FABRIC: 100% stretch washable nylon

COLOR: White

STYLE: Parade style with a 3 line moc-stitched ribbed back.

CONSTRUCTION: Thumb portion to be clute cut. The cuff portion is to be turned and zig zag stitched. All other sewing is to utilize safety stitching. All stitching shall be done with first quality thread, silk or polyester, with thread closely matching the color of the material.

SIZES: Extra small, regular, and extra large.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-43

DESCRIPTION: LEATHER HIGH HEEL DRESS PUMP

NAME: Ali (Style 771)

STYLE: Black Leather 19/8 heel pump

PATTERN: Ali

LAST: Preview

UPPER MATERIAL: Black Smooth Leather

QUARTER LINING: Split Leather

VAMP LINING: Tricot

INSOLE: Cushioned

OUTSOLE: Composition

HEEL: 19/8 Full Breasted

SHANK: Steel

BOTTOM LINER: Cushion

COUNTER: Leather

BOX TOE: Polystyrene

WELT: Cement Construction

SOLE-STITCH: N/A

LACES: N/A

SIZES: Slim (S) - 7 thru 9, 10
Narrow (N) - 6 thru 9, 10, 11, & 12
Medium (M) - 5 thru 10, 11, & 12
Wide (W) - 6 thru 10, 11, & 12
E Wide (EW) - 6 thru 10

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-44

DESCRIPTION: LEATHER MEDIUM HEEL DRESS PUMP

NAME: Kathy (Style 724)

STYLE: Black Leather 14/8 heel pump

PATTERN: Kathy

LAST: Kathy

UPPER MATERIAL: Black Leather

QUARTER LINING: Split Leather

VAMP LINING: Tricot

INSOLE: Cushioned

OUTSOLE: Composition

HEEL: 14/8 Full Breasted

SHANK: Steel

BOTTOM LINER: Cushion

COUNTER: Leather

BOX TOE: Polystyrene

WELT: Cement Construction

SOLE-STITCH: N/A

LACES: N/A

SIZES: Slim (S) - 7 thru 9, 10
Narrow (N) - 6 thru 10, 11, & 12
Medium (M) - 4 thru 10, 11, & 12
Wide (W) - 6 thru 10, 11, & 12
E Wide (EW) - 6 thru 10 & 11

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-45

<u>DESCRIPTION:</u>	LEATHER LOW HEEL DRESS PUMP
<u>NAME:</u>	Elane (Style 727)
<u>STYLE:</u>	Black Leather 12/8 heel pump
<u>PATTERN:</u>	Camille
<u>LAST:</u>	Lori
<u>UPPER MATERIAL:</u>	Black Urethane
<u>QUARTER LINING:</u>	Split Leather
<u>VAMP LINING:</u>	Tricot
<u>INSOLE:</u>	Cushioned
<u>OUTSOLE:</u>	Composition
<u>HEEL:</u>	12/8 Full Breasted
<u>SHANK:</u>	Steel
<u>BOTTOM LINER:</u>	Cushion
<u>COUNTER:</u>	Leather
<u>BOX TOE:</u>	Polystyrene
<u>WELT:</u>	Cement Construction
<u>SOLE-STITCH:</u>	N/A
<u>LACES:</u>	N/A
<u>SIZES:</u>	Narrow (N) - 6 thru 10 Medium (M) - 5 thru 10 Wide (W) - 6 thru 10

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-47

SERVICE STAR

STYLE: The style for this insignia is a gilt, clutchback five-point metal star 1/2" in diameter. The star has five ridges running from the center down to each point with a textured background between each ridge.

CLUTCH PIN: Clutch pin to be 5/16 inch long with a 1/8 inch diameter head. Typical pin is a B.A. Ballou, East Providence, RI. Item #026146 #614 or equivalent.

CLUTCH: Flat ball type clutch

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-48

CAMPAIGN HAT CARRIER

STYLE: Polyethylene plastic molded hat carrier. Molded to precisely fit the campaign style hat and protect it from crushing, brim warping and fading. Two-piece construction with handle.

COLOR: Black

MATERIAL: Polyethylene plastic

Hat Trap Brand or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-49

FUR CAP

- FABRIC:** 100% first quality Mouton, dyed black.
- STYLE:** The style shall consist of an oval crown and two piece brim. The front piece (visor) of the brim shall snap in an upright position and the brim piece (flaps) shall attach over the crown with a tape ribbon. All parts shall be double mouton.
- CROWN:** The crown shall be oval shaped and flat topped, measuring approximately 7" by 9". The crown height shall be approximately 4".
- VISOR:** The visor length shall be approximately 7 1/4" measured at the juncture of the crown and brim and the height shall be approximately 4" at the center and tapering to rounded edges. The visor shall have a metal snap placed on the inside face of the visor approximately 1" from the top edge of the visor and shall fasten to the crown.
- FLAPS:** The ear and neck flap shall be approximately 3" width at the center back and approximately 4" in width at the ears, tapering to rounded edges at the juncture of the crown and brim. There shall be a velveteen chin strap of black tape ribbon, 5/8" wide, with top stitched edges, permanently sewn into the left ear flap top seam. The chin strap shall attach to the outside right ear flap, when folded down, by a combination snap and adjustable metal buckle.
- LINING:** The lining shall be Fibre-Temp or equal backing held in place by a black quilted extra thick liner of rayon satin.
- SWEATBAND:** The sweatband shall be simulated and made of black grosgrain rayon, approximately 1" wide, with a buckram backing.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-50

DESCRIPTION: SPECIFICATION FOR U.S. IMMIGRATION BUTTONS

The button front shall be stamped with The "U.S. IMMIGRATION SERVICE" logo, as indicated below.

BUTTON FRONTS shall be 24 and 36 line (5/8" and 7/8" respectively) of CDA 230 Alloy, soft .012 +/- .001 and .016 +/- .001 respectively. The button front shall be free of nicks, dents, scratches or other imperfections.

BUTTON BACKS shall be brass swage back - shell CDA 230 alloy, soft .016 +/- .001 and shank 230 alloy, soft wire .072. The eyes shall be smooth and free of burrs. The back shall be stamped with the manufacturer's trademark or other legible identifying mark.

BUTTON FRONTS will be stamped with the letters "U.S." centered on the button and with the word "IMMIGRATION" arched in a semi-circle across the top of the button. The word "SERVICE" shall be placed on the button in a reverse arch along the bottom of the button. All letters will be in capitals. The background shall be in fine line.

BUTTON FRONTS shall be finished with 24K yellow gold electro deposited plate and have a burnished rim. Buttons shall be closed firmly and evenly with no burrs, nicks, dents or sharp edges. There shall be single dip lacquer on both fronts and backs of buttons.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

1992 - GN-51

COVERED KEY HOLDER

GENERAL DESCRIPTION

The key holder is designed to carry keys on the standard 2 1/4" belt in a covered fashion. It is of the snap-on belt loop style.

Dimensions and Descriptions

Height:	4 1/2"
Width:	2 1/4"
Thickness:	1 3/4"
Weight:	2.9 oz.
Color:	Black
Finish:	Plain
Belt loop slot:	2 1/4"

MATERIAL AND CONSTRUCTION

The leather shall be selected from full grain vegetable tanned cowhide of a grade and clarity suitable to its purpose. Its nominal weight shall be 7 oz. to 8 oz. in thickness. It shall be free of open blemishes, brands, scars, fat wrinkles and other defects that would render the material unsuitable for the purpose intended. All cases use securely fastened snaps designed to provide a 2 1/4" belt loop opening. The covered key case closure is accomplished with Velcro brand hook and loop and closes in a wrap around fashion.

Stitching

All stitching shall be performed on a lock stitch compound feed sewing machine using #69 nylon thread. The stitching shall be six to eight stitches per inch. All stitch ends must be fused, back stitched or over sewn by a minimum of three stitches. Skipped, broken or loose stitches are not allowed. Prior to stitching, the face is embossed with a deep channel sewing guide. This sewing channel ensures that the thread stitched does not extend above the surface of the leather; thus ensuring a minimum of thread abrasion during the useful life of the product.

Finish

The leather shall be vat dyed with a minimum of 90% penetration and sealed. The sealer shall be of a material that does not crack or peel under normal use and provides a lustrous, satin finish appearance. The key holders will have a smooth face with a decorative crease line placed 1/8" from the edge.

Hardware

All exposed hardware is of corrosion resistant material with brass finish. Snaps shall be attached tightly to prevent spinning and in such a fashion as to allow proper, secure closure.

BIANCHI model 31C or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

1992 - GN-52

DESCRIPTION: FLASHLIGHT HOLDER

Flashlight holder is made of plain black leather. It is designed to fit a 2 1/4" belt and hold a "D" size flashlight with a slot in the ring for the switch to slide through. The holder is 5/8" wide with two brass snaps.

MATERIAL:

LEATHER: 7/8 oz. full grain leather free from scars and open cuts.

SNAPS: Solid brass snaps with a lacquer finish.

RING: High impact black plastic designed to fit a "D" size flashlight.

CONSTRUCTION:

1. Leather strap is cut from leather and creased with a decorative outline crease.
2. All edges are burnished and finished to a smooth edge.
3. Leather is dyed in a penetrating dye and is sealed with a lacquer emulsion to prevent the dye from rubbing off.
4. Ring is inserted and held in place by the male portion of snap and the brass cap portion is added to opposite end of strap.

Strong Model A 542 or equivalent

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

1992 - GN-53

MINI FLASHLIGHT HOLDER

I. GENERAL DESIGN AND CONSTRUCTION

The case shall be constructed of two leather parts: the front that is premolded to fit the contour of the light and the back that is folded to form the belt loop.

A Pull-A-Dot snap stud is riveted to the back.

The case is then sanded, edged and form molded.

The final step will be to install the button and socket on the back to form the belt loop.

II. DETAILS

- A. EDGES - To be edged with a #2 rampart hand edger, or equal, to give a rounded effect on edges.
- B. GLUING - Applied to both parts and pounded together.
- C. SEWING - Approximately six stitches per inch and sewn tightly.
- D. BURNISHING - All edges shall be burnished to a smooth finish with a deburring wheel, using a hard burnishing wax.
- E. SANDING - All sewn edges are to be sanded smooth.

III. MATERIAL

A. LEATHER

- 1. Kind - Top grain cowhide
- 2. Weight - 6 to 7 oz.
- 3. Grade - Full grain

B. HARDWARE

- 1. Snap - One Pull-A-Dot snap
 - a. Dot XE 18100 nickel button
 - b. Dot BS 18303 nickel snap
 - c. Dot XX 18201 nickel socket

C. THREAD

1. Kind - Polyester V346
2. Other - Mill dyed to match color black

D. DYE

1. Kind - Oil base Aniline dye
2. Other - All parts will be dyed twice during assembly.

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose
2. Other - Must have a semi-gloss finish.

F. GLUE

1. Kind - All purpose leather cement

Don Hume Model D107 Plain or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE
UNIFORM PROGRAM SPECIFICATION

1992 - GN-54

KEY RING HOLDER

I. GENERAL DESIGN AND CONSTRUCTION

The strap shall measure 10" in length and approximately 5/8" in width. The strap will be folded 3 1/2" from one end and the key hook riveted in place. Two durable dot snaps will be installed. The button at the long end and the stud at the opposite end will begin 1/2" from their respective ends and be 1" apart. The key ring will be snapped to the key hook.

II. DETAILS

- A. EDGES - To be edged with a #3 hand edger, or equal, to give a rounded effect on the edges and dyed with Flexolon water base epoxy acrylic edge sealer.
- B. GLUING - N/A
- C. SEWING - N/A
- D. BURNISHING - N/A
- E. CREASING - All edges shall be creased with a #5 creaser.

III. MATERIAL

A. LEATHER

- 1. Kind - Vegetable tanned top grain cowhide
- 2. Weight - 7 to 8 oz.
- 3. Grade - Full grain

B. HARDWARE

- 1. Snap - Two durable dot snaps and key hook Z-714 3/4"
- 2. Rivet - CE125 6/16" Stimpson
- 3. Key ring - North & Judd # 6805 1 1/4" diameter

C. DYE

- 1. Kind - Oil base Aniline dye

D. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

Don Hume Model S501-1 Plain or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-55

INSULATED BOOT SOCK

DESCRIPTION: Socks shall be available in all sizes and so designed to provide extra toe, bottom and heel support areas. The sock shall be over-calf style.

Construction shall be approximately 70% insulating hollow-core polyester, 20% orlon acrylic and 10% Spandex.

Color to be available in both black and white.

THORLO STYLE SKX OR EQUIVALENT

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-56

CLIP ON BADGE HOLDER

I. GENERAL DESIGN AND CONSTRUCTION

The badge holder is to fit one shield badge. The construction shall be two leather parts: the snap-off loop and the front. The loop is riveted to the front. The Tru-Form Clip is installed. A baby dot snap is then installed in the loop permitting easy removal of badge. The edges are to be finished smooth with epoxy acrylic edge sealer.

II. MATERIAL

A. LEATHER

1. Kind - Top grain cowhide
2. Weight - 6 to 7 oz.
3. Grade - Full grain

B. HARDWARE

1. Snap - One set baby dot, japanned finish
2. Rivet - Two CE100 5/16"
3. Other - One Tru-Form Clip - 7/8"

C. THREAD

1. Kind - Polyester
2. Size - V346
3. Other - Mill dyed to match product color

D. DYE

1. Kind - Oil base Aniline dye
2. Other - All parts must be dyed before assembly

E. FINISH

1. Kind - Pigmented acrylic with a top coat of Nitrocellulose.
2. Other - Must have semi-gloss finish.

F. Glue

1. Kind - All purpose leather cement

Don Hume Model C312 Plain or equivalent.

UNITED STATES IMMIGRATION AND NATURALIZATION SERVICE

UNIFORM PROGRAM SPECIFICATION

1992 - GN-57

NAME PLATE

MATERIAL: Brass alloy #342, 65% copper, 33% zinc, 2% lead

METAL

FINISH:

1. Blanks tumble deburred, smooth all edges and corners
2. Grease buff front surfaces
3. Polish front surfaces to a high lustre
4. Apply satin brushed finish to entire front surface

PLATING AND COATING:

1. Electroplate gold hamilton shading
2. Spray and bake on two coatings of clear epoxy baking lacquer

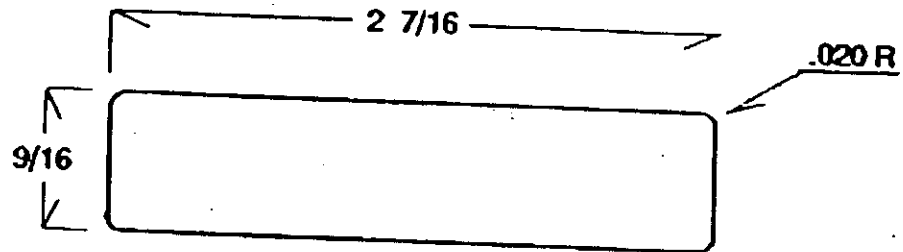
LETTERING: Pantograph plain Gothic block letters with a medium extension, .250 inch high and .020 inch stroke. Machine to depth of .010 inch and color-fill with black, air dry enamel. Lettering to consist of first initial, middle initial (if applicable) and surname and family lineage indicators ie; Sr., Jr., etc. as applicable.

CLUTCH PINS: Two 5/16 inch ling triple grooved clutch pins applied by electron fusion.

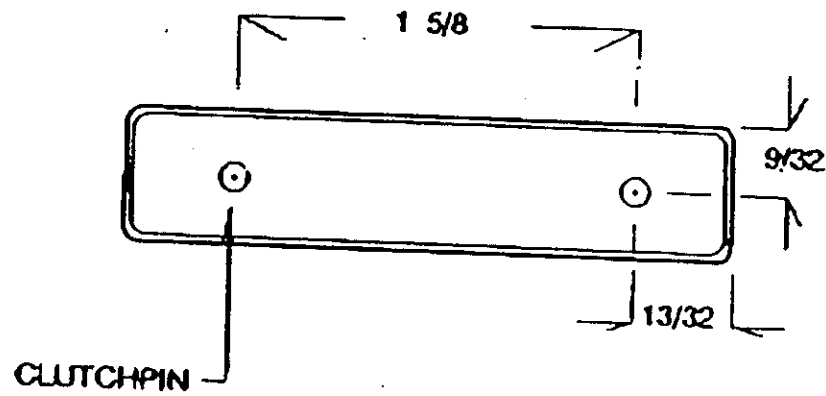
GRIPPERS: Brass tie tack pin gripper with rounded head and covered gripper area for each clutch pin. Typical pin gripper is a B.A. Ballou, East Providence, RI. Item #200.

Reeves Company, Attleboro, MA Model #N8 or equivalent

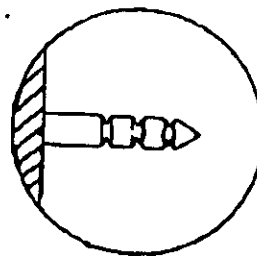
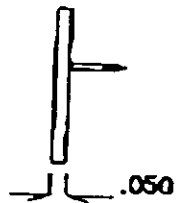
FRONT
1:1



BACK
1:1



EDGE
1:1



3 GROOVE PIN 5/16" LONG